

## INSTALLATION INSTRUCTION 0001-0790-999

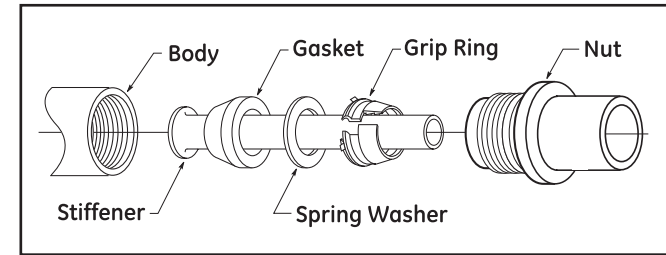
# Style 501 Transition Couplings

With SEAL-PLUS™ Restraining Ends

### FOR WELDED INLET AND THREADED INLET X 501 POLYETHYLENE TUBING COMPRESSION OUTLET TAP-N-VALVE TEES

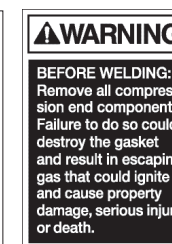
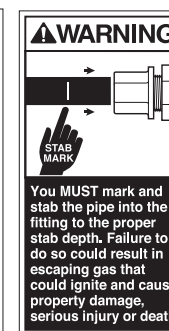
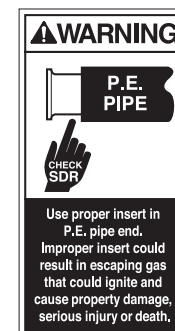
1. On weld inlet tees, remove tapping tool and all compression end components. Do not remove weld splatter cap from tee inlet.
2. For threaded inlet tees, apply pipe thread compound to threads and attach to the main. For weld inlet tees, weld to main and allow to cool to hand touch prior to reassembly of tapping tool & compression end components. (Reassemble parts in the sequence and orientation shown.)
3. Cut tubing square and deburr. Tubing must be clean and free of longitudinal scratches. At lower temperature a slight chamfer approximately 1/16" x 45° on the end of tubing will facilitate insertion into the fitting.
4. Make sure nut flange is 1/4" to 5/16" from body contact.
5. Mark tubing for stab depth; 2-3/4" for 1/2" CTS (5/8" O.D.) thru 1"CTS (1-1/8" O.D.), 3" for larger sizes.
6. Check stiffener to assure it is for wall thickness of tubing used (see color code chart).
7. Stab tubing into fitting until it bottoms. If properly stabbed, the tube markings will be inside or not over 1/8" from the UNTIGHTENED nut. **STABBING NOTE:** This fitting does not grip when the tubing is stabbed. If difficulty is encountered in stabbing, withdraw the tubing and try reinserting again. (Be sure nut flange is at least 1/4" from body.) After proper stabbing is determined, **THE NUT MUST BE HAND TIGHTENED TO ACTUATE THE GRIP RING FOR HOLDING THE TUBING IN PLACE DURING FINAL TIGHTENING.**
8. Tighten nut until flange contacts body. (Do not overtighten.)
9. Check stabbing marks on tubing. If mark is over 9/16" from the tightened nut on 1/2" CTS (5/8" O.D.) thru 1"CTS (1-1/8" O.D.) sizes and over 5/8" on larger sizes, the end must be disassembled. After disassembly, check if stab mark length is correct. In reassembling an improperly stabbed end, cut off the tubing to eliminate the gripper teeth marks, reassemble parts in proper order, remark tubing, and then repeat the connection procedure.
10. See other side for tapping instructions.
11. Rotate tool counterclockwise until flush with top of tee.
12. Apply thread compound on pipe threads and tighten cap.

**NOTE: The gasket, spring washer and grip ring are held in place with shrink-wrap to facilitate assembly at the factory. The shrink-wrap does not need to be removed and is designed to break away during installation. However, if the fitting is disassembled following an improper installation, the shrink-wrap must be discarded prior to reassembly of the fitting as noted in Step 9 above.**



#### COLOR CODE CHART

Tubing Wall (Any Diameter)	Stiffener Color
.062	Red
.077	Blue
.090	Silver
.099/.101/.103	Gold
.121	Black



Dresser™ Pipeline Solutions  
41 Fisher Avenue  
Bradford, PA 16701  
P: 814.362.9200  
F: 814.362.9344  
www.dresserengs.com

© 2018 Natural Gas Solutions North America, LLC. The Dresser Logo and all Trademarks containing the term "Dresser" are the property of Dresser, LLC, a subsidiary of Baker Hughes, a GE Company.

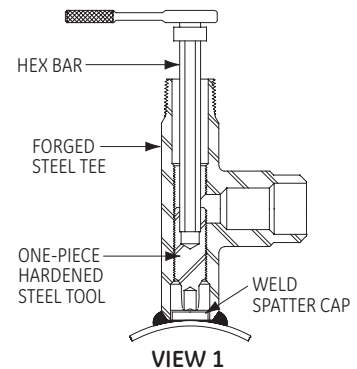
Part No. 0001-0790-999  
BAG.12.2018

# INSTALLATION INSTRUCTION 0001-0790-999

## Style 90 TAP-N-VALVE Tee

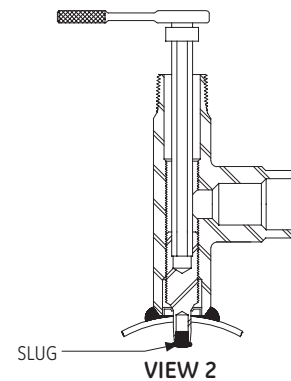
### VIEW 1

1. Tapping tee is assembled in saddle or welded to main. Tee is supplied with spatter cap to prevent spatter from entering the internal threads. If inlet must be ground to fit small pipe sizes and cap must be removed, anti spatter welding compound should be applied to reduce the likelihood of spatter entering the threads causing tool seizure. Spatter cap can be pushed further into tee if required. Tapping tool must be removed from inside the tee while welding.  
**IMPORTANT:** Place tool in plastic bag while welding. (After welding, tee must be cool to touch before reinserting tool.)
2. Hollow, cutting end of tapping tool is then inserted in top of tee and threads are engaged. Leave weld spatter cap in place to prevent slag from entering threads.
3. A hex bar and 14" ratchet wrench are used to rotate the tapping tool in a clockwise direction. Turn down until cutting edge touches the main.



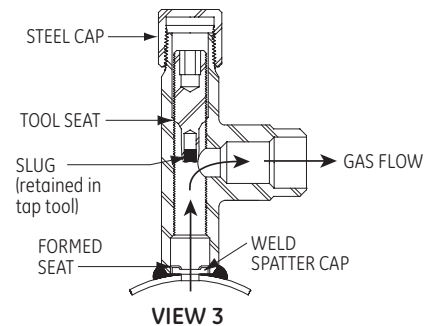
### VIEW 2

4. To make the tap, continue clockwise wrenching. Once tap has been started in pipe, tool should not be retracted until tap is completed and tool is seated. As tip of tool penetrates through the pipe wall, the required wrench pull or torque will decrease. The operator will feel the seating of the tool on the pipe because the pull will again increase sharply. Apply sufficient torque to seat the tool.
5. Tap is now completed. The tool is seated and the slug is retained in the tool.

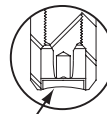


### VIEW 3

6. To admit gas to branch, the wrench is rotated in counter-clockwise direction until top of the tool is flush with top of tee body.
7. Apply thread sealing compound to both the cap and tee thread.
8. Cap is tightened on tee body and service connection is complete.
9. Compression branches – Refer to Style 65B, 88 or 90 coupling Installation Instructions.



**NOTE:** Field contouring of the tee weld inlet to the pipe radius is suggested to improve weld prep and helps to reduce weld burn-through and internal weld spatter.



Field-contoured inlet

### TAP TOOL APPLICATION CHART

TAPPING TOOL (DIAM)	MAXIMUM PIPE WALL	MAXIMUM PIPE SMYS
1/4"	3/8"	52,000 PSI
3/8"	3/8"	42,000 PSI
1/2"	1/4"	42,000 PSI

### WARNING

On Weld Inlet Tees, remove tapping tool and all compression end components before welding. Failure to do so could damage the tapping tool and destroy the gasket, resulting in escaping gas that could ignite and cause property damage, serious injury or death.



NATURAL GAS SOLUTIONS

Dresser™ Pipeline Solutions

41 Fisher Avenue

Bradford, PA 16701

P: 814.362.9200

F: 814.362.9344

www.dresserngs.com

© 2018 Natural Gas Solutions North America, LLC  
The Dresser Logo and all Trademarks containing the term "Dresser" are the property of Dresser, LLC, a subsidiary of Baker Hughes, a GE Company.

Part No. 0001-0790-999

BAG.12.2018